

Wednesday, 30/07/2008 5:33:31 PM
e Lecocq

Process Sheet

: CU-DAR001 Dart Helicopters Services
 Job Number : 40833
 Estimate Number : 13517
 P.O. Number :
 This Issue : 30/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 30/07/2008 Type : SMALL /MED FAB
 Previous Run : 40765
 Written By :
 Checked & Approved By : JUD 08-8-01
 Comment : Est Rev:A 08-07-24 new issue ec verified by:dd

Drawing Name : BRACKET
 Part Number : D21973
 Drawing Number : D2197 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 20/08/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .500 x 5.00



Comment: Qty.: 0.1985 f(s)/Unit Total: 0.3969 f(s)
 6061t6 bar 5.00" x .50" thick
 batch: 106747 IB 8-8-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2197
 Dwg Rev: C IB 8-8-21
 Prog Rev: C

2-Deburr if necessary

A 08/08/21 (2) rtm

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/08/21 (2)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

08/08/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/07/2008 5:33:31 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40833

Part Number: D21973

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MP-00-22 *JP*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock
Location: *18*

6/8/25

(2x)

34

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25 *JA*

Job Completion



W 08-08-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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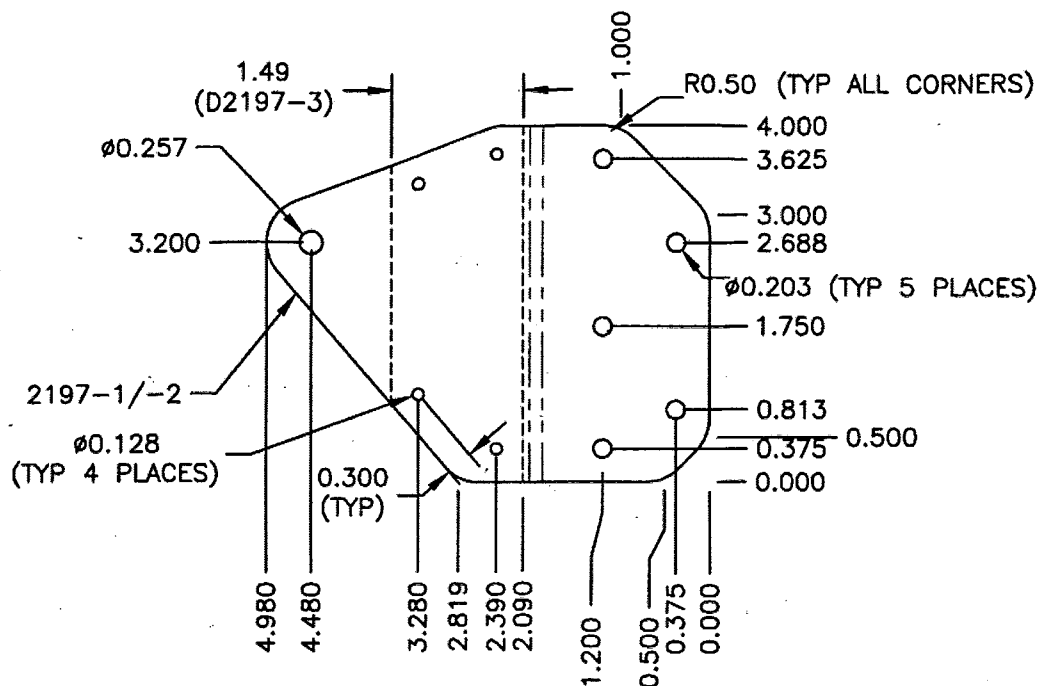
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28	TITLE BRACKET		SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

RELEASED
03.07.04

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

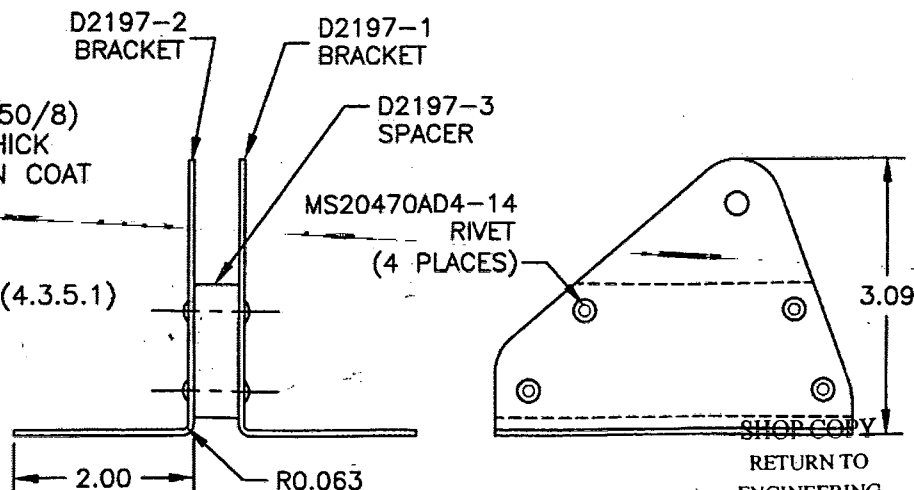
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
-PER DART-QSI-005 4.1.

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET
(ASSEMBLY)

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40833

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